

PHI - Cmo Yrge Blde - Shp Nov. 20!

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 1

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

**1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

**1*

Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/

Operation

Set Up/

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

Blank Contour ID

Description

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Draw Nbr

Revision Nbr

D3274-041

F

109

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-642-541

CHG005

N/A

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 2

Item ID: D206-642-541

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop

NS2

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Main Center ID
110

Operation
Description

Set Up/
Down Time
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Status

110

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M430137

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6-Clenco DT8025 in position and install pilot hole drill jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BE 14-10-27

DGC 14-10-28

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 3

Item ID: D206-642-541

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop

NS2

Start Date: 10/17/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/

Work Center ID

Operation

Procedure

Set Up/

Time

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

114

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

① 14-10-29

DAS
9
9-89

116

116

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

① 14-10-29

DAS
9
3-89

120

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

14-10-29

[Handwritten Signature]

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 4

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
--------------------------------	--------------------------	-----------------	---------	--------	--------------	---------------	---------------	------------------	-----------------

130

QC7-Inspect Chemical Conversion Coat

0.00

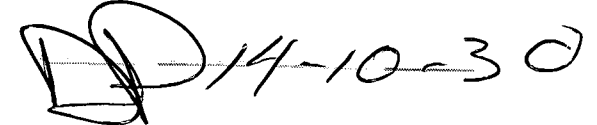
130

QC

Memo

0.00

Quality Control



150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

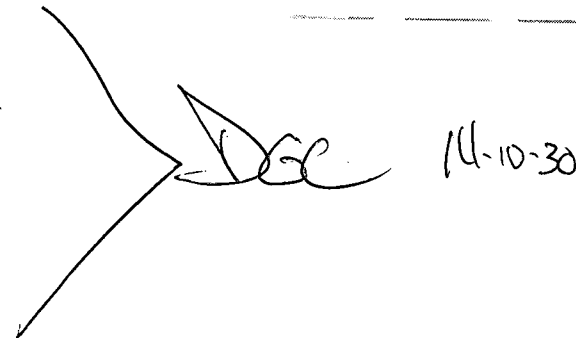
A/R Sikaflex-291 130227

Sikaflex expire date: 16-02-05

Start: _____ Time: 11-15AM

Finish: _____ Time: _____

(Adhere for 12 hours)



Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 5

Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status	
160	QCS- Inspect part completeness to step on W/O	0.00				1	0	14-11-03		DAS 18 9-09
160										
QC	Memo	0.00								
Quality Control										

170

0.00

170

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr **DO NOT DRILL HOLES FOR LONG WEAR PLATES.**

3-DRILL TOR PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DGC
14-11-3
JH

PTO
D

14-11-3

DQA: Aut Date: 14/12/08

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 8.0.9.1 Date: 14/12/12Work Order update only ☐

Work Order: <u>125632</u> Part No. <u>D206-642-541</u> NCR No. <u>14-4281</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework <input type="checkbox"/>	Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input checked="" type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Aft Band 3.187"		use as is			
Doc/Data					DAS 12 9-89		DAS 12 9-89		DAS 9 9-89
Equip/Tooling		170	1		14/11/3	Acceptable	14/11/3	14-11-3	14-11-03
Handling/Pre	14-11-3								
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input checked="" type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 6

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/

Work Center ID
180

Operation

Inspection

QC5- Inspect part completeness to step on W/O

Set Up/

0.00

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

DAS
18
9-89

180

QC

Quality Control

Memo

as per
MTO

0.00

1 0 14-11-04

190

190

Skidtube

Skidtube

Skidtube

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod ML30137

BB14-11-04

3-Grind cross bolt welds flush as per Dwg D3274.
****INSPECT FOR FIN HOLES IN WELD****

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

14-11-04

October-17-14 10:18:05 AM

Page 7

Setup Start *NS1*

NS2

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

DAS

9

~~9-89~~

DAS

9

9-89

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

Hand Finishing

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 8

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 **

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 **

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time H:M:S	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Reason	Insp. Status
--------------------------------	--------------------------	-----------------------	---------	--------	--------------	---------------	---------------	------------------	-----------------

230

SprayPaint

Spray Painting

Memo

0.00

Make sure Nut Plate Thread is protected using paint screw.

1- PRIME AS PER DWG AND QSI 005 4.2

USE:

PRC Desoto Primer 515X349 (Boeing Spec BMS 10-79 Type III Class A Coat)

A) PRIME INSIDE AND OUTSIDE OF TUBE

2-SPRAY PAINT PER QSI

USE: CA 8213/F37038 CAMOFLAGE

BLACK - MIL-PRF-05285B, TYPE 1, CLASS H

128975

130804

CR 14.11.08

240

QC14- Inspect Spray Paint

0.00

240

QC

Quality Control

Memo

0.00

124 111 1414

DAS
15
9-89

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 9

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
244	Wing Walk as per dwg QSI005 4.4 Batch <u>M1302</u>	0.00							
244	HandFinish								
Hand Finishing	Memo	0.00							
246	QC3- Inspect Part Finish	0.00							
246	QC								
Quality Control	Memo	0.00							

38
9-89

14-11-21

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 10

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ From ET	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Material	Insp. Status
250	HandFinishing	0.00							
250	HandFinish								
Hand Finishing	Memo	0.00							

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 1122960

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/Sikaflex-291 14128979

Sikaflex expires date: 1506

260

QC5- Inspect part completeness to step on W/O 0.00

260

QC

Memo 0.00

Quality Control

Inspect Nut Plate & Inserts

1 0 14-11-21

DAS 34 888

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 11

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
270	HAND FINISHING RESOURCE #1	0.00							
270	Memo	0.00							
Hand Finish	1-Install wearpads & gaskets as per Dwg D3274.								
Hand Finishing	2-Install ring as per Dwg D3274 A/RSikaflex-291 <u>11/10/14</u> Sikaflex expire date: <u>12/10/14</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 <u>11/10/14</u> Sikaflex expire date: <u>12/10/14</u>								
280	QC5- Inspect part completeness to step on W/O	0.00							
280	Memo	0.00							
QC									
Quality Control									

DO NOT INSTALL
LONG WEAR PLATES

14 10/21/14

DAS
38
9-89

14-11-21

Work Order ID 125632

October-17-14 10:18:05 AM

125632

Page 12

Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 ***1***


Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description Identify as per dwg & Stock Location: _____	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
290		0.00							
290									
Packaging	Memo	0.00			DAS				
Packaging					GS				
					9-89				
									NOV 21 2014
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

14/11/21 

 14-11-21

October-17-14 10:18:01 AM

125032

D206-642-541

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1,00

Required Qty: 1.00

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKI/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC
REV:H 13.09.05 CHG004/ ECN13-634 DD VERR:JLM IPP REV:I
14.04.28 AS PER ECN14-520 DD VERR:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3274-041BENT		Manufactured	No			110	Each	13.0000	1	1			
D3274-041BENT													
Skidube Assembly 206									**				

BE14-10-27

DE 14-10-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	10	
122974	10	
LQ002	3	
113682	1	
120287	2	

D4956-15		1207287		2	
Manufactured	No	270	Each	23.0000	1
D4956-15					
Stainless Steel Wearplate Fwd					
	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
	FP002		23		
	122996		10		
	124078		13		
D4956-23					
Manufactured	No	270	Each	19.0000	1
D4956-23					
Stainless Steel Wearplate Center Fwd					
	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
	FP002		19		
	121755		6		
	124079		13		

N/A
NOT REQUIRED
[Signature]

October-17-14 10:18:01 AM

125632

D206-642-541

Start Date: 10/17/14

Required Date: 11/07/14

~~NOT~~
NOT
REQUIRED.

Manufactured	No
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
9	9
10	10
11	11
12	12
13	13
14	14
15	15
16	16
17	17
18	18
19	19
20	20
21	21
22	22
23	23
24	24
25	25
26	26
27	27
28	28
29	29
30	30
31	31
32	32
33	33
34	34
35	35
36	36
37	37
38	38
39	39
40	40
41	41
42	42
43	43
44	44
45	45
46	46
47	47
48	48
49	49
50	50
51	51
52	52
53	53
54	54
55	55
56	56
57	57
58	58
59	59
60	60
61	61
62	62
63	63
64	64
65	65
66	66
67	67
68	68
69	69
70	70
71	71
72	72
73	73
74	74
75	75
76	76
77	77
78	78
79	79
80	80
81	81
82	82
83	83
84	84
85	85
86	86
87	87
88	88
89	89
90	90
91	91
92	92
93	93
94	94
95	95
96	96
97	97
98	98
99	99
100	100

110

Each

30.0000



D3285-1

Cap

Location

LG

Loc City

30

30

Loc Code

1.0000

D3282-041

Manufactured	No
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
9	9
10	10
11	11
12	12
13	13
14	14
15	15
16	16
17	17
18	18
19	19
20	20
21	21
22	22
23	23
24	24
25	25
26	26
27	27
28	28
29	29
30	30
31	31
32	32
33	33
34	34
35	35
36	36
37	37
38	38
39	39
40	40
41	41
42	42
43	43
44	44
45	45
46	46
47	47
48	48
49	49
50	50
51	51
52	52
53	53
54	54
55	55
56	56
57	57
58	58
59	59
60	60
61	61
62	62
63	63
64	64
65	65
66	66
67	67
68	68
69	69
70	70
71	71
72	72
73	73
74	74
75	75
76	76
77	77
78	78
79	79
80	80
81	81
82	82
83	83
84	84
85	85
86	86
87	87
88	88
89	89
90	90
91	91
92	92
93	93
94	94
95	95
96	96
97	97
98	98
99	99
100	100

150

Each

1.0000

;

1

D3282-041

Float Web (206L/407)

Location

LG002

Lec City

books

1990

Loc Code

113149

125295

DGC 14-10-30

October-17-14 10:18:02 AM

Shop Packet Print

Picklist Print

October-17-14 10:18:02 AM

Page 3

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D2649

Manufactured No

190

Each

340.0000 12 12

Required Qty: 1.00

D2649

Cross Bolt Spacer

★★

BE14-11-03

Location

Loc Qty

Loc Code

LG

128

123099

128

LG001

212

107906

3

112728

6

113811

2

120508

195

90497

6

D3275-1

Manufactured No

190

Each

117.0000 12 12

D3275-1

Crossbolt Spacer

★★

BE14-11-03

Location

Loc Qty

Loc Code

LG001

117

113246

1

113851

62

114877

1

121868

1

121974

52

CR3212-4-03

Purchased No

250

Each

985.0000 2 2

CR3212-4-03

Cherry Rivet

★★

14/4/20

Location

Loc Qty

Loc Code

ST321

985

114889

1

119017

700

m114859

100

m123265

184

October-17-14 10:18:03 AM

Shop Packet Print

Page 3

Picklist Print

October-17-14 10:18:03 AM

Page 4

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3415-041

Manufactured No

250

Each

17.0000

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Nut Plate

**

B126635(1x) 11/16/14

Location

Loc Qty

Loc Code

ST037

17

113764

17

CCR264SS3-3

Purchased

No

250

Each

419.0000

2

2

CCR264SS3-3

Cherry Rivet

**

11/16/14

Location

Loc Qty

Loc Code

ST321

419

113973

26

m126282

43

m126333

66

m128636

84

m128818

200

ALS4-1032-130

ABLS4-1032-130

Purchased

No

250

Each

3,693.000

78

ALS4-1032-130

Rivnut

**

78 40 11/16/14

Location

Loc Qty

Loc Code

ST267

3693

M126109

57

M128211

48

M128649

3588

40

October-17-14 10:18:03 AM

Shop Packet Print

Page 4

Picklist Print

October-17-14 10:18:03 AM

Page 5

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3537-3

Manufactured No

270

Each

56.0000

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Wearpad

**

ell 44/6/19

Location

Loc Qty

Loc Code

PG

8

86237

8

13126377

x1

FP001

8

111825

1

113789

1

115122

6

FP002

40

120646

40

D3537-1

Manufactured No

270

Each

28.0000

9

9

D3537-1

Wearpad

**

ell 14/6/19

Location

Loc Qty

Loc Code

PG

18

79833

8

13126378

x9

88562

10

FP001

10

113839

4

120644

5

93945

1

October-17-14 10:18:03 AM

Shop Packet Print

Page 5

Picklist Print

October-17-14 10:18:03 AM

Page 6

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

NAS1149C0332R

Purchased

No

270

Each

Start Qty: 1.00
8,749.000 80

Required Qty: 1.00

NAS1149C0332R
WASHER

40 *ll whaling*

Location	Loc Qty	Loc Code
CA	83	
m129682	83	
ST278	8666	
122063	41	
125654	425	
m126319	51	
m127306	2065	
m127831	26	
m128591	75	
m129499	191	
m130325	4792	
m130466	1000	

NAS1149C0463R

Purchased

No

270

Each

535.0000

1

NAS1149C0463R
Washer

1 *ll whaling*

Location	Loc Qty	Loc Code
ST278	535	
119097	1	
123248	1	
123355	55	
m127306	123	
m128401	355	

ll

October-17-14 10:18:03 AM

Shop Packet Print

Page 6

Picklist Print

October-17-14 10:18:03 AM

Page 7

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3672-1

Manufactured No

270

Each

Start Qty: 1.00
897.0000 2 2

Required Qty: 1.00

D3672-1

Washer, Phenolic

all vlc/lg

Location	Loc Qty	Loc Code
FG	10	
85222	10	
ST055	887	
113581	466	
120116	379	
80369	34	
99099	8	

12

AN3C4A

Purchased No

270

Each

881.0000 80

48

vlc/lg

AN3C4A

Bolt

Location	Loc Qty	Loc Code
FG	20	
122814	20	
ST350	861	
124221	12	
M127410	1	
M127832	62	
M128606	32	
M128634	8	
M128739	4	
M128879	71	
M129520	671	

M130716

V48

October-17-14 10:18:04 AM

Shop Packet Print

Page 7

Picklist Print

October-17-14 10:18:04 AM

Page 9

Work Order ID: 125632

125632

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3413-1

Manufactured No

270

Each

31.0000

Start Qty: 1.00

Required Qty: 1.00

D3413-1

O-Ring

**

126637 (1) 11 11/17

Location

Loc Qty

Loc Code

STS25

31

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

8

October-17-14 10:18:04 AM

Shop Packet Print

Page 9

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2848	AFT CAP
12	12	D2849	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4956-15	WEARSHOE
1	1	D4956-23	WEARSHOE
1	1	D4956-35	WEARSHOE
1	1	D4956-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C418	WASHER
80	80	AN960C10L	WASHER
2	2	CCR284SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: N/A
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
 - PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 - BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 20.8 LBS
- WELDING TO BE DONE PER DART QSI 004.
- ALL HOLES DRILLED ON CENTERLINES.
- DAMAGE TOLERANCE ON FWD BEND:

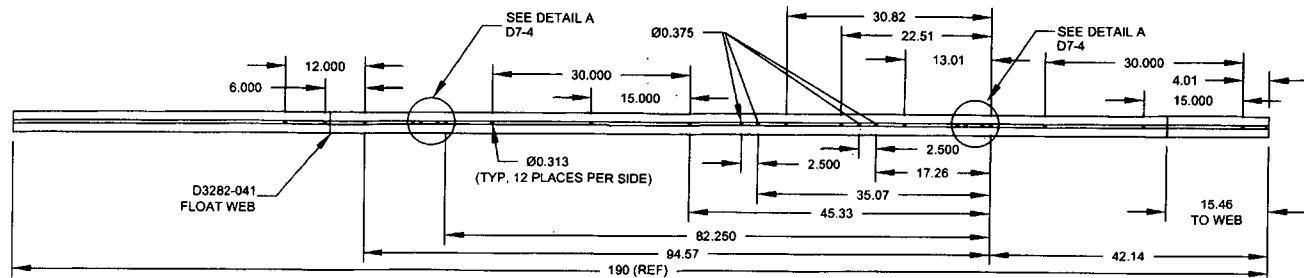
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.



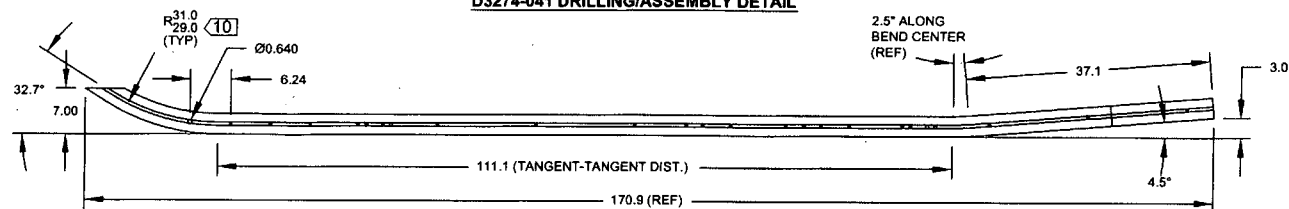
W/O 125632

RELEASED
2014-05-26

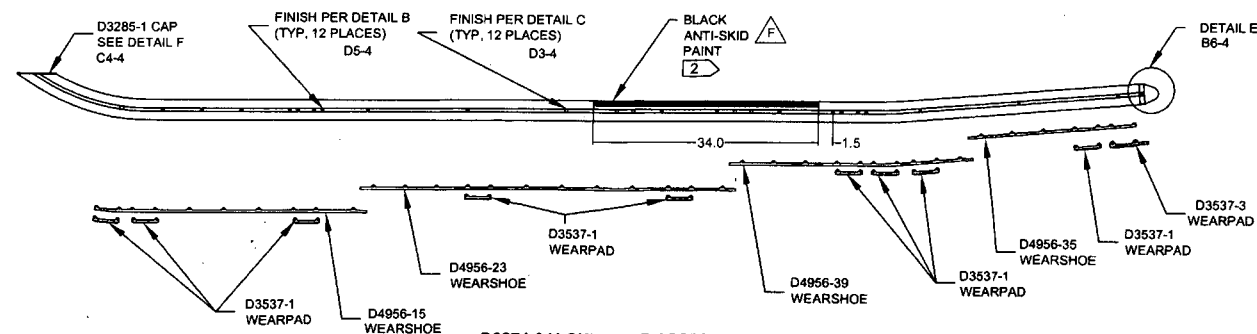
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D206-642 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -043; NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	



D3274-041 DRILLING/ASSEMBLY DETAIL



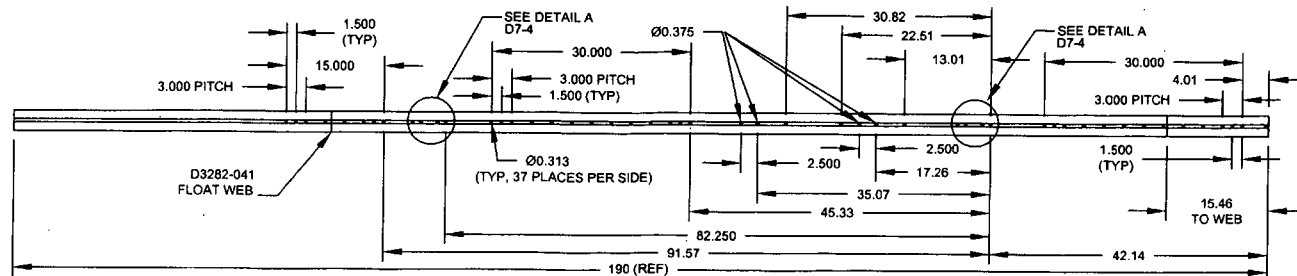
D3274-041 BEND/DRILLING DETAIL



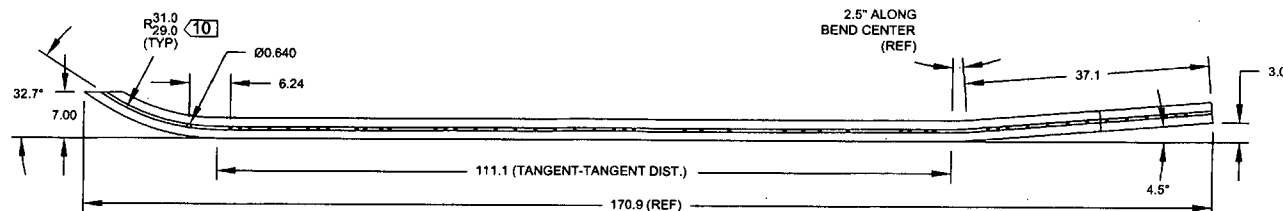
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

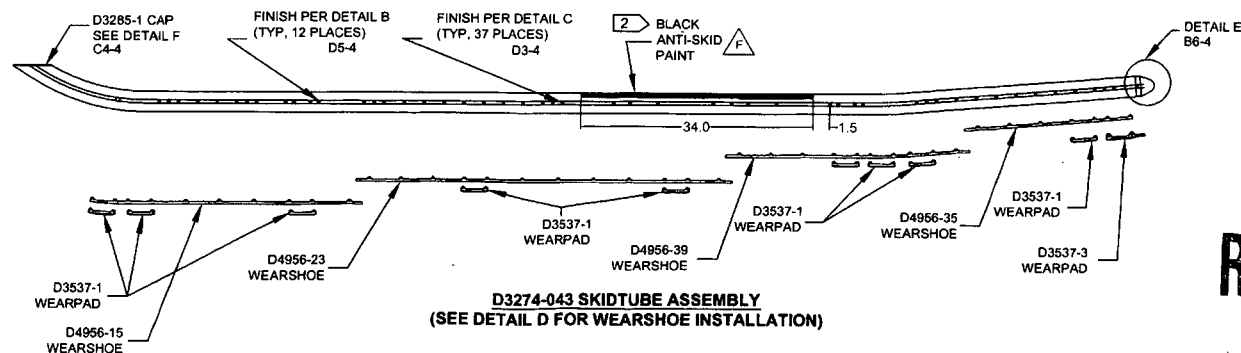
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	DW	DRAWING NO.	REV. F
MFG. APPR.	DB	D3274	SHEET 2 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	<small>COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

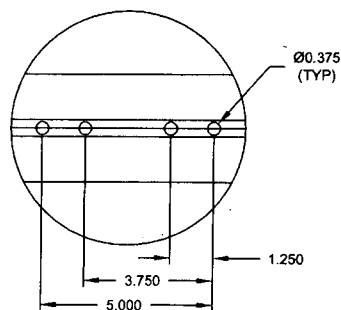


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

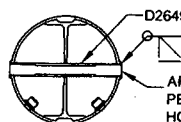
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	4.04.15
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	

DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

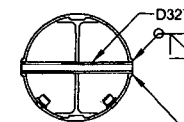
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

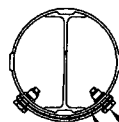
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



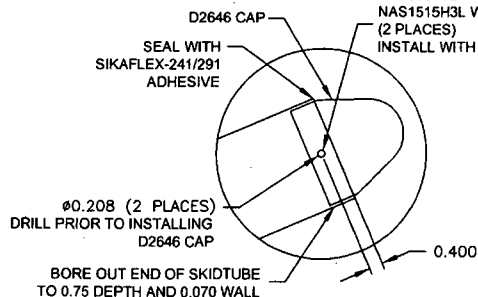
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3

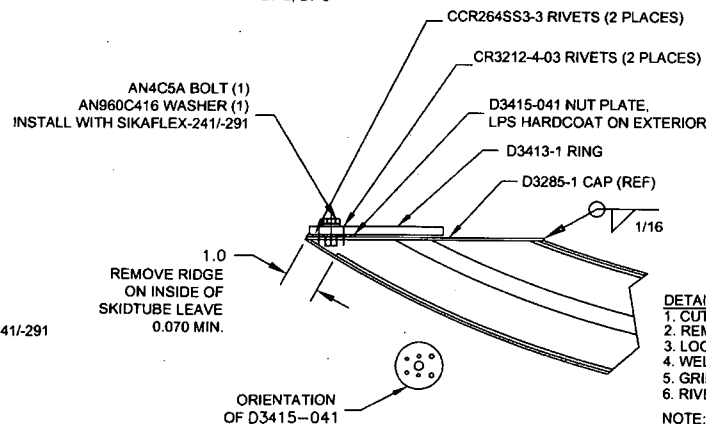


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26
AND

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	AP	DRAWING NO. D3274	REV. F
MFG. APPR.	AP		SHEET 4 OF 4
APPROVED	AP	TITLE SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	AP		
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	